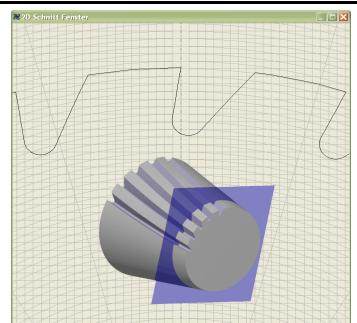


Bandsaw Cutter Ø130 Z20

A03-401

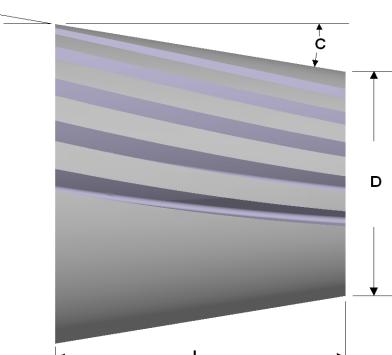
Resharpening of the face of helicoidal and tapered Bandsawcutters requires to use the conical side of the wheel in order to get a rake face as straight as possible. Quinto allows to grind the face in 2 different ways, either as a constant rake offset or as a constant rake angle. If necessary, the face grinding process can be subdivided into a pregrinding and finishing operation with 2 different wheels.



1. Cycletime for Resharpening

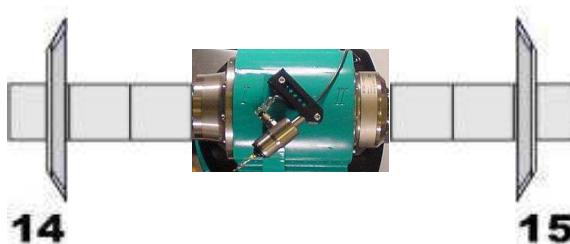
Tool specifications			
D 130 mm, Z 20, L 160 mm, Helix -7°, incr. 0.4 mm, C 12°			
Material HSS			
Operations			
Feed [mm/Min]	2000	400	2000
Power [kW]		2	1
Cutting feed [m/s]		32	32
Used wheels			
Grinding time [s]	26	930	524
Total cycle time	24 Min 39		

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.



2. Used Grinding Wheels

15 Ø125 1V1 B126
14 Ø125 1V1 B126



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR, NORMA CFG, Tailstock
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.2, Standardtools

responsible engineer: OP,21.4.07

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